

Date: Monday, 08/12/2008 1:55:20 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BASKET LID ASSEMBLY		
Job Number	: 43942B			Part Number	: D2989043		
Estimate Number	: 10207			Drawing Number	: D2989 REVD		
P.O. Number	:			Project Number	: N/A		
This Issue	: 08/12/2008	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 22/12/2008		
Previous Run	: 43941B			Qty:	1	Um:	Each
Written By	:						
Checked & Approved By	: <u>JLM 08-12-08</u>						
Comment	: Est Rev:I Removed D2989-041 05-11-03 JLM Est Rev:J 08-08-29 revC as per dwg DD verified by:EC Est Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC Est Rev:L 08-12-02 revD as per dwg DD verified by:						
Additional Product							
Job Number: 							
Seq. #:	Machine Or Operation:	Description :					
1.0	D29893	Rib 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)							
✓ Rib batch: <u>B 43996 → 1x</u> <u>DL 09/01/13</u>							
2.0	D29894	Rib 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)							
✓ Rib batch: <u>B 43997 → 1x</u> <u>DL 09/01/13</u>							
3.0	D29895	Rib 					
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)							
✓ Rib batch: <u>B 43998 → 2x</u> <u>DL 09/01/13</u>							
4.0	D298917	Rib 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)							
✓ Rib batch: <u>B 43994 → 1x</u> <u>DL 09/01/13</u>							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 43942B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D31821 Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Hinge

batch: B43293 → 2x

SL 09/01/13

6.0 D34423 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Shim

batch: B42718 → 2x

SL 09/01/13

7.0 D3827041 Rib Assembly (Inboard)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Rib Assembly (Inboard)

batch: B44011 → 1x

SL 09/01/13

8.0 D38325 Mesh (Lid)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Mesh (Lid)

batch: B44014 → 1x

SL 09/01/13

9.0 D38335 Mesh (Lid End)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Mesh (Lid End)

batch: B44017 → 2x

SL 09/01/13

10.0 D3838041 Rib Assembly (Basket Lid, LH)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Rib Assembly (Basket Lid, LH)

batch: B44020 → 1x

SL 09/01/13

11.0 D3838042 Rib Assembly (Basket Lid, RH)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Rib Assembly (Basket Lid, RH)

batch: B44021 → 1x

SL 09/01/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/12/2008 1:55:20 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 43942B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- assemble all ribs in DT9446 jig, weld as per dwg D2989 *SL*
- 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig *SL*
- 3- to locate hinges and shims use D2989-041, weld as per dwg D2989 *SL*

A/R ER316 S.S. Rod Batch: M108775

SL 09/01/14

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-01-20

14.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/01/20 (X)

15.0

POWDER COATING

POWDER COATING



M 109996

Comment: POWDER COATING

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME:

2:30pm

OVEN TEMPERATURE:

400°F

FINISH TIME:

3:07pm

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

09-01-20

(X1)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

EJ 09/01/27 (D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 43942B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Le 09/01/2008

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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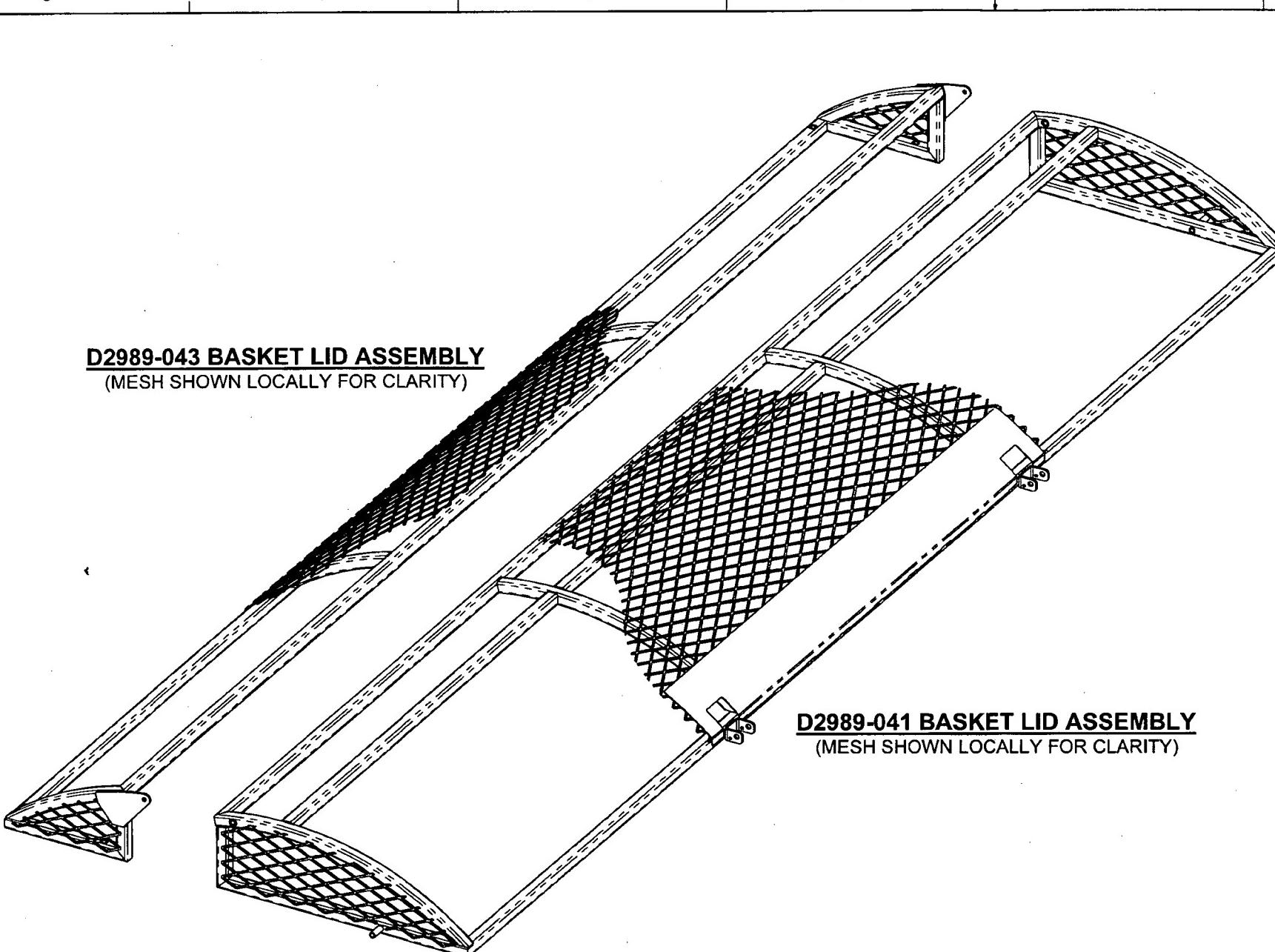
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

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08/11/18 MTD
 NO. 43942B

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 WITHOUT NOTICE
 WORK ORDER

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9-15; D3836-042 REPLACES D2989-10-15; D3838-041 REPLACES D2989-1-7; D3838-042 REPLACES D2989-2-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9-10 (NOW ON D3836 DWG), D2989-1-2/7-15 (NOW ON D3838 DWG) AND D2989-11-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D2989	
CHECKED		REV. D SHEET 1 OF 5	
MFG. APPR.		TITLE BASKET LID ASSEMBLY	
APPROVED		SCALE NTS	
DE APPR.			
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

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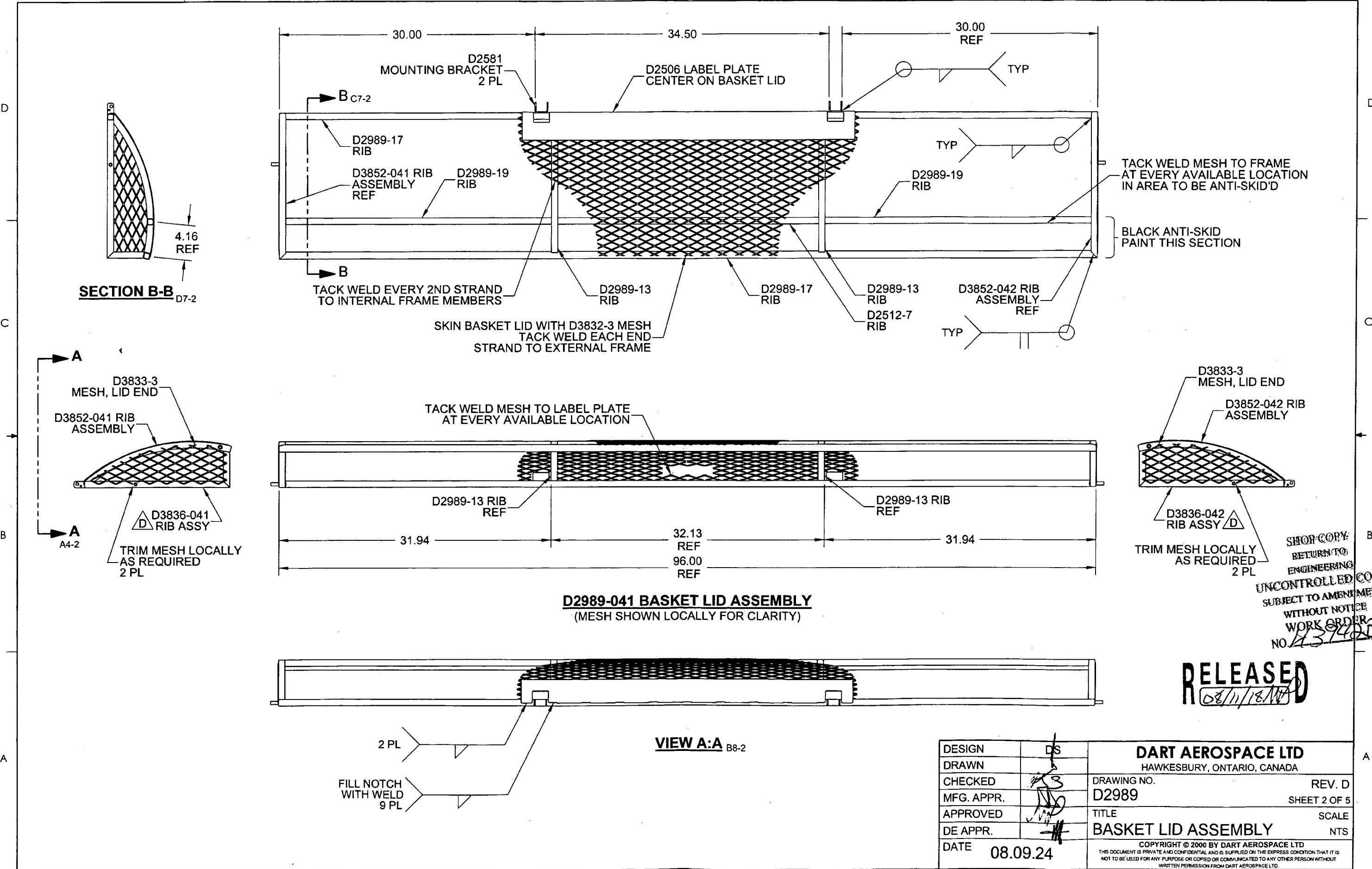
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8 7 6 5 4 3 2 1 .



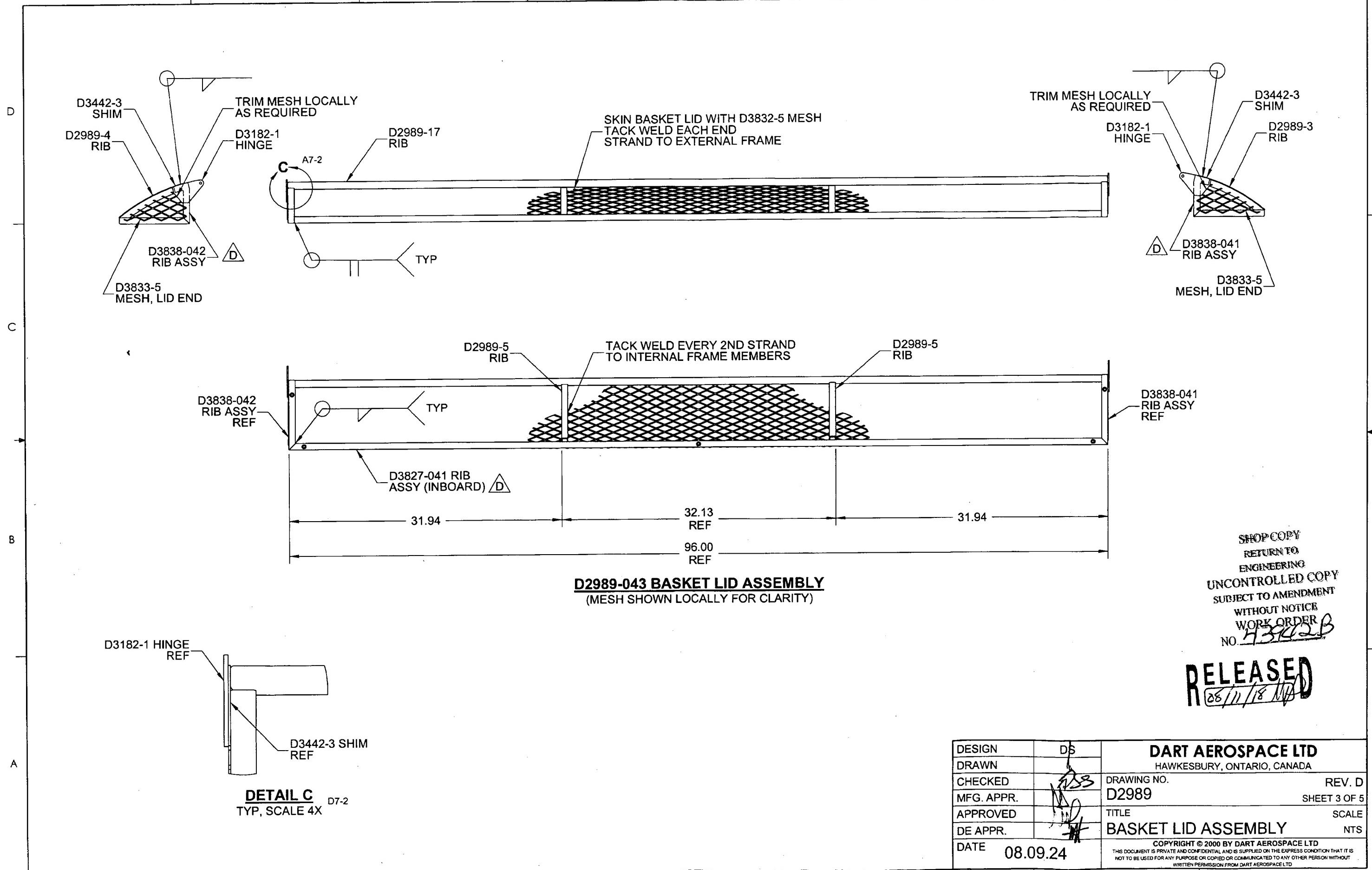
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08/11/18/MJ

VIEW A:A

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	#3	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED	V/V	TITLE	SCALE
DE APPR.	-	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

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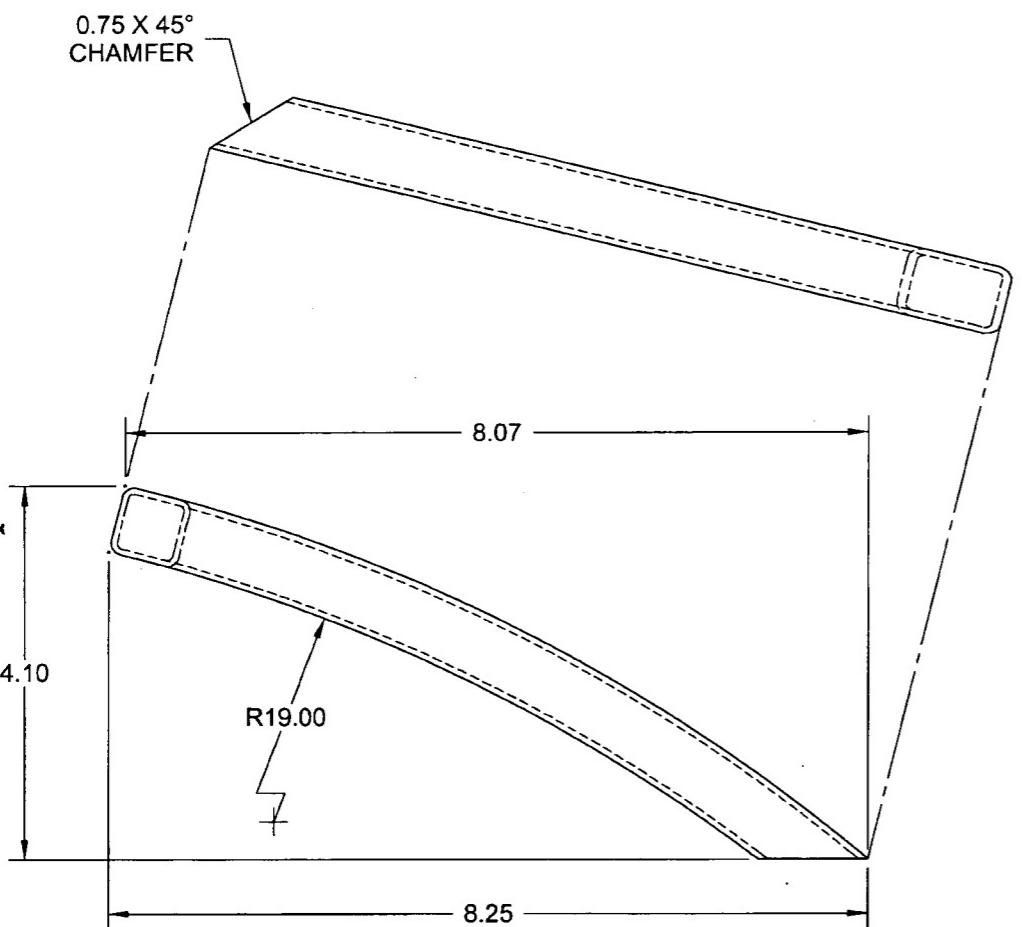
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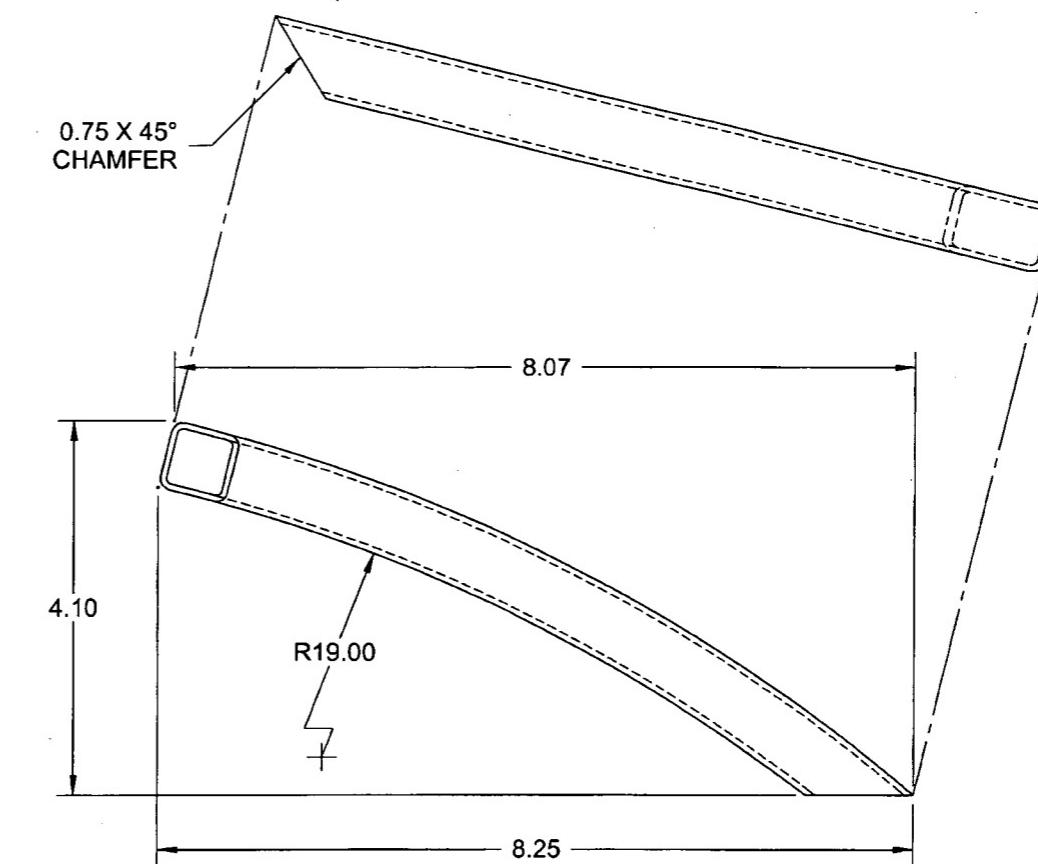
8 7 6 5 4 3 2 1

D

D



D2989-3 RIB



D2989-4 RIB

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WORK ORDER NO. 43074D

RELEASED
08/11/18 MW

B

B

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C

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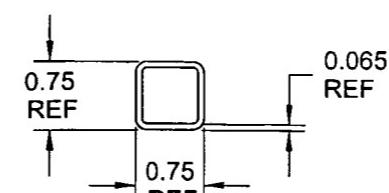
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NOTES:

- 1) MATERIAL: D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



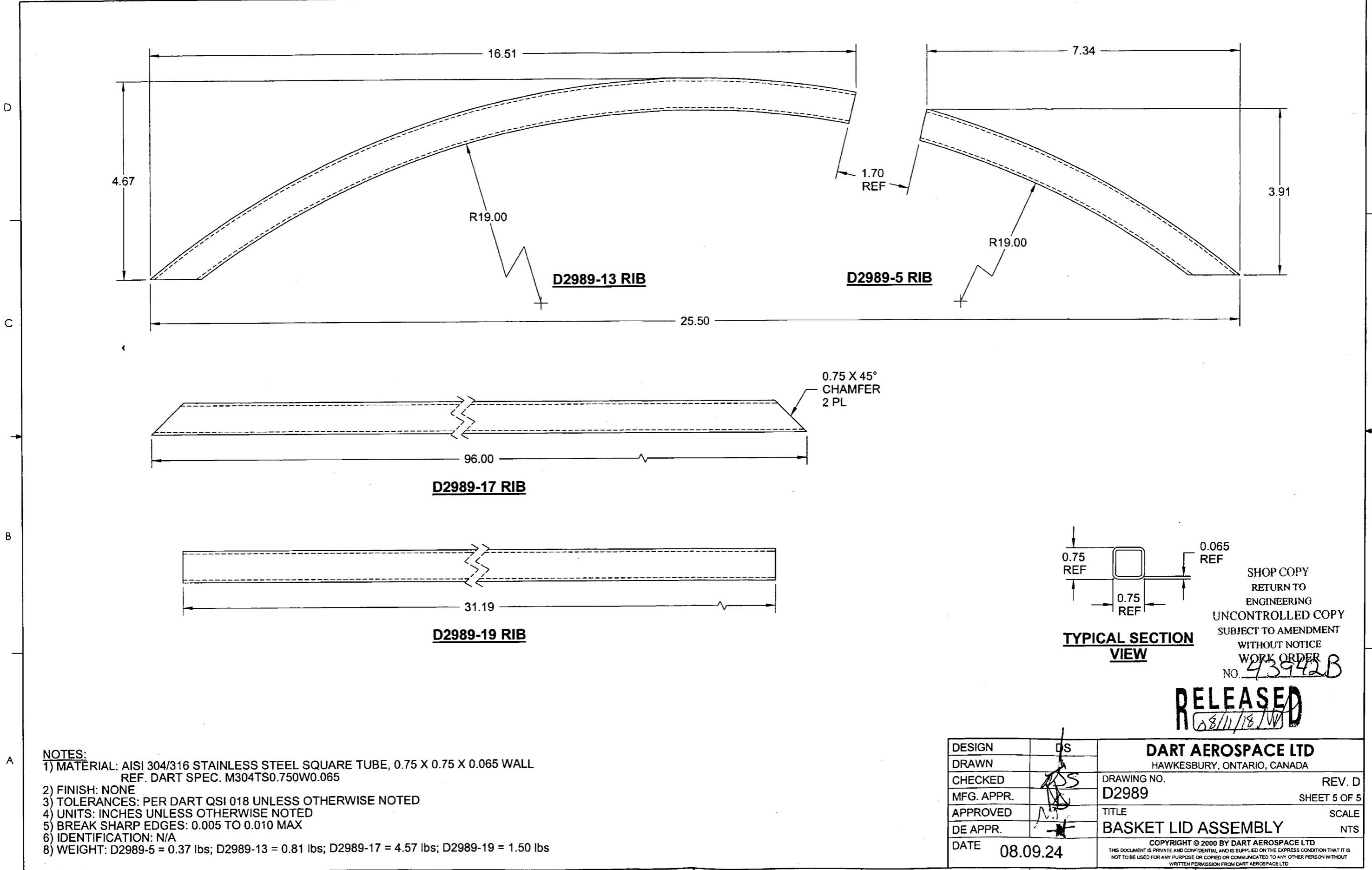
TYPICAL SECTION
VIEW

DESIGN	DS	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D2989
MFG. APPR.		REV. D
APPROVED		SHEET 4 OF 5
DE APPR.		TITLE
DATE	08.09.24	SCALE
		BASKET LID ASSEMBLY
		NTS

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08/11/18